

48

58.22

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	19896
<b>Description:</b> Bearpaw Kit (19" x 16")	<b>Part Number:</b>	K10007
<b>Dwg:</b> D2435 Rev. E1	<b>Qty:</b>	20 <i>a</i>
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler <b>Note: (1) K10007 Kit consists of Qty (2) D2435 Dwg not required</b>	JD	03.11.06	20																																																
2	DC	Photocopy bluefile: K10007 D206-559 D500-572 D120-638 D058-678  and create labels per PPP K10007 CHG003 <b>(Bag Bluefiles separately)</b> WK 46 WJ	JD	03.11.13 04.01.15	10 10																																																
3	GA	<b>Cut 2 blanks per K10007 Kit</b> Cut blank: 16.00" x 20.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) <b>Identify as D2435</b> Batch: 114320 114711	RG P.D	04-01-26	10 10																																																
4	MV	Inspect material for defects or damage prior to machining	JD	04/01/29	20																																																
5	MV	Machine as per Folio D2435 and Dwg D2435	JD	04/01/29	20																																																
6	QC2	Inspect parts as they come of the CNC machine	JD	04/01/29	20																																																
7	MV	Deburr	JD	04/01/29	20																																																
8	QC8 & 5	Second inspection	EL	04.02.01	20																																																
9	KP	<b>Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3)</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2182B050</td><td>Rubber Cushion</td><td>B19540</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B19599 B19922</td></tr><tr><td>2</td><td>D2435</td><td>Bearpaw</td><td>B19896</td></tr><tr><td>4</td><td>D2438</td><td>Clamp</td><td>B200899 B19615</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B20090 B18930 B19486</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>m13437</td></tr><tr><td>8</td><td>AN4-17A</td><td>Bolt</td><td>m13536 m12692</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>m13719</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>m13276 m13928</td></tr><tr><td>2</td><td>QS200M44S</td><td>Clamp</td><td>m14019 m13928 m14312</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2182B050	Rubber Cushion	B19540	8	D2274	Radius Block	B19599 B19922	2	D2435	Bearpaw	B19896	4	D2438	Clamp	B200899 B19615	8	D2529	Washer	B20090 B18930 B19486	8	AN4-15A	Bolt	m13437	8	AN4-17A	Bolt	m13536 m12692	16	AN960JD416	Washer	m13719	8	MS21042L4	Nut (or -4)	m13276 m13928	2	QS200M44S	Clamp	m14019 m13928 m14312	1	Paperwork package from Step 2			me	04/1/16	20
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10	QC4	Inspect Kit for 100% Completeness on the W/O	Q	04-02-02	20																																																
11	PK	Identify and pack for shipping as per PPP K10007	Q, me	04-02-02	20																																																
12	AC	Cost / part 162.20	S4C	04-02-03	20																																																
13	DC	Close W/O 156.57 Inspect Level 21	JA	04.02.03	20																																																

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10007 created for Bear paw kit (MPP 2000)	EC	
B	01.03.21	Added OH-58 paperwork (MPP 2092)	EC	
C	01.11.08	Revised Step 3 and Added Level 21	SM	
D	03.03.26	Reformat; Incorporated D2435	KJ/RF	<i>JD</i>

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**NOTE:** Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 05, 2003  
12:32 pm

Work Order No : 0019896  
Project Name : \*K10007  
Project For : WK348  
Work Order Type : Main  
Main WO Number :  
House Part Number : \*K10007  
Description : Bearpaw Kit 19" x 16"  
Manufactured : Yes  
Amount Req'd : 1020  
Amount Done : 0  
Start Date : 11-05-03  
Est Finish Date : 11-27-03  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	19896
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓			
B	5.500	+/-0.030	5.515	✓			
C	0.200	+/-0.030	0.194	✓			
D	R0.250	+/-0.030	0.250	✓			
E	0.250	+/-0.010	0.255	✓			
F	0.625	+/-0.030	0.632	✓			
G	0.25 x 45°	+/-0.030	0.264 x 45°	✓			
H	0.375	+/-0.010	0.385	✓			
I	19.000	+/-0.030	19.000	✓			
J	0.950	+0.030/-0.010	0.974	✓			
K	Ø0.260	+0.005/-0.000	0.260	✓			
L	Ø0.930	+/-0.030	0.923	✓			
M	0.30	+0.030/-0.000	0.310	✓			
N	0.375	+/-0.030	0.394	✓			
O	7.375	+/-0.030	7.375	✓			
P	4.250	+/-0.010	4.260	✓			
Q	2.000	+/-0.030	1.982	✓			
R	9.000	+/-0.010	9.000	✓			
S	15.750	+/-0.030	15.750	✓			

Measured by: <i>GP</i>	Audited by: <i>RE</i>	Prototype Approval:	N/A
Date: 04/01/27	Date: 04.01.27	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	<i>[Signature]</i>

**RELEASED**

04.01.15